



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBW6205G12731-3G
Job Sheet 173112



Part No: RBW6205G12731-3G

Job Qty: 1 ea

Part Name: Upper Plate Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/26/18

Job Tracking No:

Due Date: 3/23/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW6205G12731-3G REV 3 IPP REV A 18.02.15 NEW ISSUE FK VERIFY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		3/23/18	0.00	0.00	Start Up Container		
100	Purchasing	1 pcs		3/23/18	0.00	0.00	Purchasing		A/18/05/01
110	Packaging	1 pcs		3/23/18	0.00	0.00	Packaging2		A/18/05/01
120	QC	1 pcs		3/23/18	0.00	0.00	QC6		38
130	Packaging	1 pcs		3/23/18	0.00	0.00	Packaging3		9-B9
140	QC21-SA	1 Ea		3/23/18	0.00	0.00	QC21		MAY 02 2018

Part Op 100 - 1- Issue P/O to Arrow Tech Machine Works P/O# 039145 2- Manufacture RBW6205G12731-3G as per
Descriptions: DWG 3- Certificate of conformity is required

8102 8 2 FEB 18

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBW6205G12731-3GP	Upper Plate Assembly	1 (1 ea)	90-Start up Operation	5067416

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	RBW6205G12731-3GP	1	0	0

Part Specifications

Specifications could not be found.

Plex 2/26/18 12:39 PM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

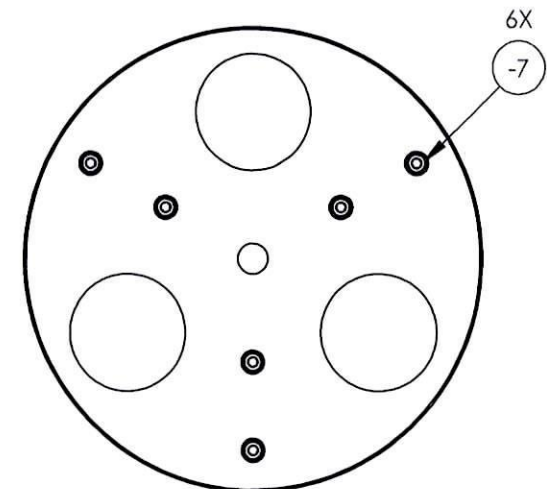
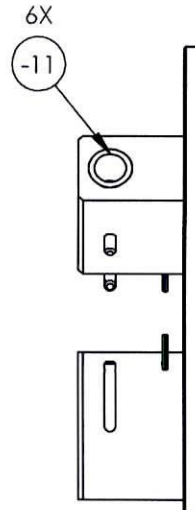
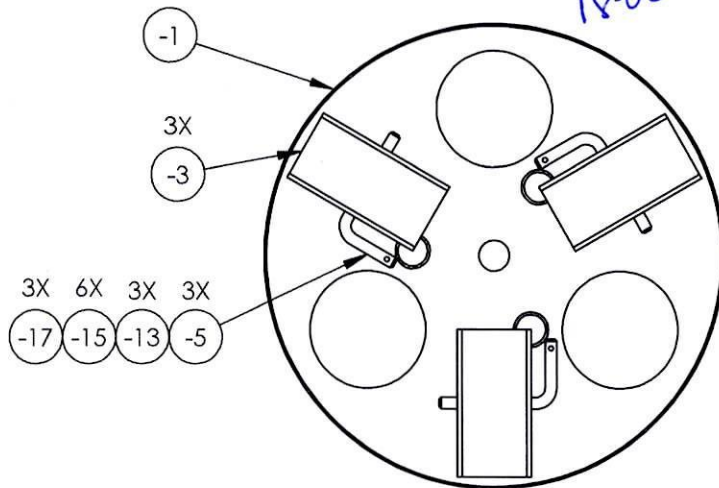
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval																																																	
Description Work Order: _____ Change No: _____ Operation: _____ Revision: _____ Serial No/Batch: S067417 PART NO: RBW6205G12731-3G Upper Plate Assembly Job No: 173112 Mfg Date: 05/01/18 Packaging				Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____																																																	
Root Cause <table style="width:100%; border-collapse: collapse;"> <tr><td>Environment</td><td>☐</td><td>No Re-verificat</td><td>☐</td></tr> <tr><td>Design</td><td>☐</td><td>Operator</td><td>☐</td></tr> <tr><td>Doc/Data</td><td>☐</td><td>Offset/Setup</td><td>☐</td></tr> <tr><td>Equip/Tooling</td><td>☐</td><td>Supplier</td><td>☐</td></tr> <tr><td>Handling/Pre</td><td>☐</td><td>Training</td><td>☐</td></tr> <tr><td>Material</td><td>☐</td><td>Use for Testing</td><td>☐</td></tr> <tr><td>Internal Transport</td><td>☐</td><td>Poor Information</td><td>☐</td></tr> <tr><td>Tribal Knowledge</td><td>☐</td><td>Rushing</td><td>☐</td></tr> <tr><td>LOA</td><td>☐</td><td>Product Improvement</td><td>☐</td></tr> <tr><td>Substation</td><td>☐</td><td>Process Improvement</td><td>☐</td></tr> <tr><td>Past Expiry Date</td><td>☐</td><td>Manufacturing Process</td><td>☐</td></tr> <tr><td>Misidentified</td><td>☐</td><td>Past Due</td><td>☐</td></tr> </table>		Environment	☐	No Re-verificat	☐	Design	☐	Operator	☐	Doc/Data	☐	Offset/Setup	☐	Equip/Tooling	☐	Supplier	☐	Handling/Pre	☐	Training	☐	Material	☐	Use for Testing	☐	Internal Transport	☐	Poor Information	☐	Tribal Knowledge	☐	Rushing	☐	LOA	☐	Product Improvement	☐	Substation	☐	Process Improvement	☐	Past Expiry Date	☐	Manufacturing Process	☐	Misidentified	☐	Past Due	☐	 Container No: S067417  ge lled			
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OTHER : _____																																																					

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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 173112 M-5
18-02-26

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		-1 ADDED ENGRAVE ASSY. T/N NOTE. -3 CH'D HOLE FROM Ø.3125 +.005-.000 TO Ø.3150 +.005-.001 & CH'D P.F. -40 TO P.F. -11. CORRECTED ENGRAVE NOTE P/N. -5 CH'D MATERIAL OVERALL LENGTH, ADDED ISSING DIM.	1/20/2011	RJC	RW
1A		-9 DELETED FROM BOM, NOT USED.	5/24/2011	RJC	RW
2		-1 ADDED MISSING DIM. Ø.820 FOR HOLE IN CENTER.	7/8/2011	RJC	DW
3		-3 CH'D Ø.3125 TOLERANCE FROM +.005-.000 TO ±.001, ADDED MISSING DIMS TO LOCATE HOLES.	4/15/2013	CFS	GE



NOTE:
1. REF. AGUSTA T/N: 3G6205G11331.
2. PART OF KITS RBW6205G11231-3G AND RBW6205G13831-3G.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	PLATE	6061		2
			-3	3	BLOCK	6061		3
			-5	3	PIN	1018 G&P		4
		B/O	-7	6	SOCKET HEAD CAP SCREW	STEEL	M8 X 1.25 X 25mm (MCMASTER-CARR #95263A633)	1
		B/O	-11	6	BUSHING	STEEL	Ø22 mm I.D X Ø30mm O.D. X 36mm (MCMASTER-CARR#8486A78)	1
		B/O	-13	3	SPLIT RING	STEEL	Ø.80 I.D. X Ø.07 WIRE (MCMASTER-CARR #86805T36)	1
		B/O	-15	6	FERRULE	ALUMINUM	Ø1/16 X 3/8 MCMASTER-CARR #3896T31	1
		B/O	-17	3	LANYARD CABLE	COATED STEEL	Ø1/16 X 6 (CARR LANE #CL-2-C)	1

DART AEROSPACE	
TITLE UPPER PLATE ASSEMBLY	
DWG NO. RBW6205G12731-3G	REV 3
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1	DRAWN BY: CLOUGH
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	APPROVED <i>D Weil</i>
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	HEAT TREAT FINISH SPEC
SCALE 1:5	DATE 4/30/2010
SHEET 1 OF 4	

DQA _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					

PURCHASE ORDER **P0039145**

Dart Aerospace Ltd.
 1270 Aberdeen St
 Hawkesbury, ON
 K6A 1K7
 Canada
 Tel (613) 632-5200



Supplier: ARR002-VU
 Arrow Tech Machine Works
 29751 E. Enid Road,
 Eugene, OR 97402 USA
 Phone: 541-780-6938
 Fax: 458-215-4938

Ship To:

PO No: P0039145
PO Date: 2/28/18
Due Date: 4/30/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact:
Phone:
Pynt Terms: Net 30
Freight Terms:
Special Comments:

E-MAILED
MAR 12 2018

Line	Item	Part	Supplier	Part No	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1		RBW6205G12731-	3GP		Upper Plate As Per Dwg RBW6205G12731- 3G Rev. 3	Firmed	4/30/18	1 Ea	0 Ea	1 Ea	\$2,595.37/Ea	\$2,595.37
Line Item Note Job# 173112												
2		RBW6205G13151-	3GP		Lower Plate As Per Dwg RBW6205G13151- 3G Rev. A	Firmed	4/30/18	1 Ea	0 Ea	1 Ea	\$718.91/Ea	\$718.91
Line Item Note Job# 173113												
3		RBW6205G13231-	3GP		Arm Assembly As Per Dwg RBW6205G13231- 3G Rev. 1	Firmed	4/30/18	3 Ea	0 Ea	3 Ea	\$413.50/Ea	\$1,240.50
Line Item Note Job# 173115												
4		RBW6205G13531-	3GP		Screw Assembly As per Dwg RBW6205G13531- 3G	Firmed	4/30/18	3 Ea	0 Ea	3 Ea	\$315.70/Ea	\$947.10
Line Item Note Job# 173116												
5		RBW6205G11451-	3GP		Clamp As Per Dwg RBW6205G11451- 3G Rev. 1	Firmed	4/30/18	8 Ea	0 Ea	8 Ea	\$83.64/Ea	\$669.12
Line Item Note Job# 173120												
Grand Total: \$6,171.00												

Procurement Quality Clauses
 A005 RIGHT OF ENTRY
 A008 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION SENT TO DART AEROSPACE)
 A012 CHEMICAL AND PHYSICAL TEST REPORTS
 A016 PERSONNEL QUALIFICATION
 A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
 A026 CERTIFICATION OF MATERIAL CONFORMANCE
 A041 QUALITY MANAGEMENT SYSTEM
 A042 DART NOTIFICATION BY SUPPLIER
 A043 RETENTION OF QUALITY DOCUMENT

Order Notes



ARROW TECH MACHINE WORKS

Certificate of Conformance

Your Purchase Order No:039145

Dated: 04/27/2018

Our Order / Job No: 28AWT

Order Qty: 1

Part Name: UPPER PLATE ASSEMBLY

Part Number: RBW6205G12731-3G

Lot Size: N/A

Ship Date: 04/27/2018

We certify that these parts shipped to you are of domestic or international manufacture and conform to all requirements of the Purchase Order. These parts have been manufactured and inspected in accordance with all required specifications, instructions and drawings. Any applicable specifications are listed below:

Drawing Number: RBW6205G12731-3G

Rev: 3

Material Size and Type: -1/6061 ALUM.; -3/6061 ALUM; -5/1018 STEEL

Material Specifications: ALUM: ASTM B221; STEEL: ASTM A108, ASTM A29

Heat Treatment: N/A

Plating/Finish: CLEAR ANODIZE: MIL-A-8625F, TYPE II, CLASS I; ZINC PLATE: ASTM B633, TYPE 1, SC2

Mercury Contamination: The material used to process this order has not come in contact with mercury or mercury bearing instruments.

Date:

04/27/18

Signed:

DAE
38
9-89

MAY 02 2018

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